

# Work Order ID 77761

December-21-11 9:03:15 AM

ASAP

\*77761\*

Page 1

Item ID: D350-591-312 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step, Long RH  
 Start Date: 21/12/2011 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 29/12/2011 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/12/21 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
	Non Eurocopter 002								
110	Large Fab	0.00							
*110*									
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod M114514								
	3-Grind End Plate flush M118735								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*77761\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 21/12/2011    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 29/12/2011      **Req'd Qty:** 4.00      **\* / \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

0,00

**\*120\***

QC

## Memo

0.00

## Quality Control

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

0.00

**\*140\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
180		0.00							
<b>*180*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod <u>M114514</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Memo

0.00

Quality Control

8/12/01/02

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

8/12/01/02



210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

4X/2M-12/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*77761\***

Page 5

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 Start Date: 21/12/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 29/12/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*220\***

Powdercoat

Powder Coating

Memo

START TIME: 10:30

OVEN TEMPERATURE: 320 OF

FINISH TIME: 11:00

4X2 M / 12/01/03

230

Wing Walk as per dwg QSI005 4.4 Batch 119094 0.00

**\*230\***

HandFinish

Hand Finishing

Memo

0.00

4 AL 12-1-3

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Quality Control

Memo

0.00

4RH & M 12/01/03  
 counted & identified.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 6

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Item ID: D350-591-312

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

12/14 SP (4)

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

12 01 05 (4)

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312  
Location: \_\_\_\_\_Rev D  
Loc 81  
fc

12/15 SP (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/12/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

OK 12/01/06

MF  
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

December-21-11 9:03:18 AM

Page 1

Work Order ID: 77761

\*77761\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011		Manufactured	No				Each	0.0000		4			
*DSI 9410-011*									**				
Step Modification													
D3272-1		Manufactured	No			110	Each	0.0000	1	4			
*D3272-1*									**				
Step													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		-10							
				WA		10							
D3067-1		Manufactured	No			110	Each	67.0000	1	4			
*D3067-1*									**				
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA016		67							
				67582		2							
				68214		1							
				76179		64							
D3219-1		Manufactured	No			110	Each	46.0000	2	8			
*D3219-1*									**				
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA016		46							
				73410		12							
				76226		34							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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December-21-11 9:03:19 AM

Page 2

Work Order ID: 77761

\*77761\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

D3066-1 Manufactured No

180 Each

86.0000 2 8

\*D3066-1\*

Spacer

\*\*

11.12.29

Location

Loc Qty

Loc Code

WA015

86

76180

86

8

MS20600-AD4W4

Purchased

No

180

Each

2,866.000 16

64

\*MS20600-AD4W4\*

Rivets

\*\*

11.12.29

Location

Loc Qty

Loc Code

ST321

2861

116188

59

117364

253

117601

200

117885

195

118840

1089

119860

65

119883

1000

35  
29

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

2.0000

1

4

\*D3065-041\*

Step Leg Assembly Hi

\*\*

11.12.29

Location

Loc Qty

Loc Code

WA018

2

76193

2

2 ✓

December-21-11 9:03:19 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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December-21-11 9:03:19 AM

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

180

Each

67.0000

1

4

\*D3067-1\*

End Plate

\*\*

11.12.29

## Location

## Loc Qty

## Loc Code

WA016

67

67582

2

68214

1

76179

64

Purchased

No

250

Each

103.0000

2

AN3-35A

\*AN3-35A\*

Bolt

\*\*

## Location

## Loc Qty

## Loc Code

ST353

103

119449

100

119641

3

Manufactured

No

250

Each

107.0000

2

D3235-1

\*D3235-1\*

Mounting Lug

\*\*

## Location

## Loc Qty

## Loc Code

ST481

107

73411

7

75547

100

Manufactured

No

250

Each

42.0000

4

D3278-041

\*D3278-041\*

Support Assembly

\*\*

## Location

## Loc Qty

## Loc Code

ST481

42

76169

35

76170

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16

64

\*AN960JD416\*

\*\*

Washer

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

16

\*AN960JD516\*

\*\*

Washer

AN5-36A Purchased

No

250

Each

105.0000

2

8

\*AN5-36A\*

\*\*

Bolt

## Location

## Loc Qty

## Loc Code

ST340

105

119449

30

119641

75

D2618

Manufactured

No

250

Each

112.0000

2

\*D2618\*

\*\*

Bushing

## Location

## Loc Qty

## Loc Code

ST019

112

74458

12

76130

100

D2230-3

Manufactured

No

250

Each

212.0000

4

\*D2230-3\*

\*\*

Lug

## Location

## Loc Qty

## Loc Code

ST480

212

53881

4

70973

1

75546

9

76642

198

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

250 f

200.2721 1.2

4.8

\*D2856-400\*

Abraison Strip

\*\*

## Location

## Loc Qty

## Loc Code

ST409

200.2721

63735

0.6696

68076

0.3149

71164

21.66

73491

177.6276

4.8

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

6,882.000 2

.8

\*MS21042L3\*

Nut

\*\*

## Location...

## Loc Qty

## Loc Code

ST300

6882

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

838

5

AN4-13A

Purchased No

250 Each

742.0000 8

32

\*AN4-13A\*

Bolt

\*\*

## Location

## Loc Qty

## Loc Code

ST357

742

118078

17

118838

125

119449

500

119798

100

2

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December-21-11 9:03:19 AM

Page 6

Work Order ID: 77761

\*77761\*

Parent Item: D350-591-312

\*D350-591-312\*

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 21/12/2011

Required Date: 29/12/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

250

Each

2,130.000

2

\*MS21042L 5\*

\*\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

2130

116105

5

116548

43

117611

52

118179

496

118910

34

119109

1500

MS21042L4

Purchased

No

250

Each

9,089.000

8

\*MS21042L 4\*

\*\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

9089

117441

51

117601

342

118451

133

119017

3563

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

\*AN960JD10\*

\*\*

Washer

16

m119537

12/1/11 SP/PA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 *H*

△  
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHO  
RST  
ENCL  
UNCONTR  
SUBJECT TO  
WITH  
WORK  
NO. *77761*  
*M.L.J*  
*11/12/21*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

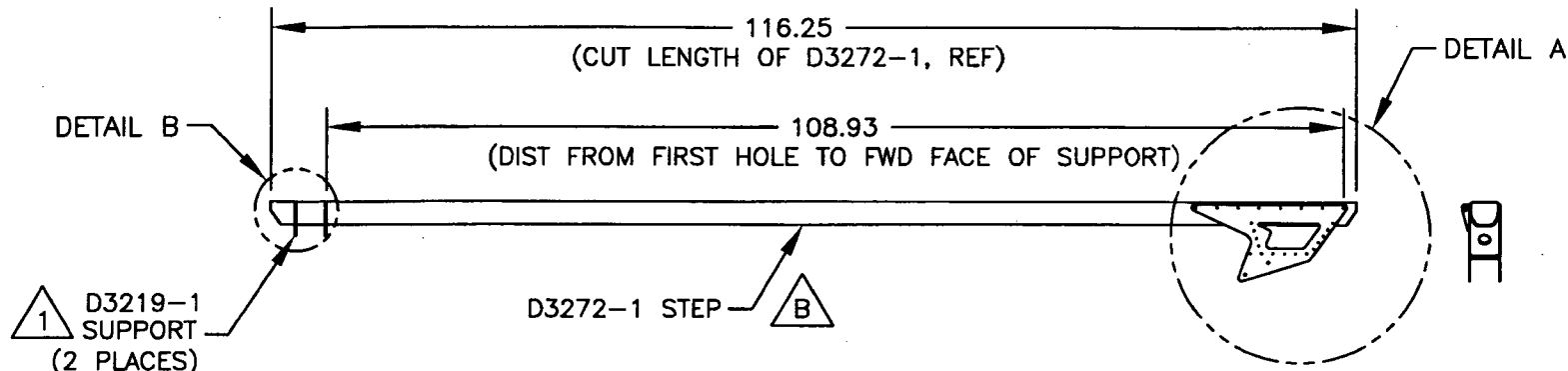
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

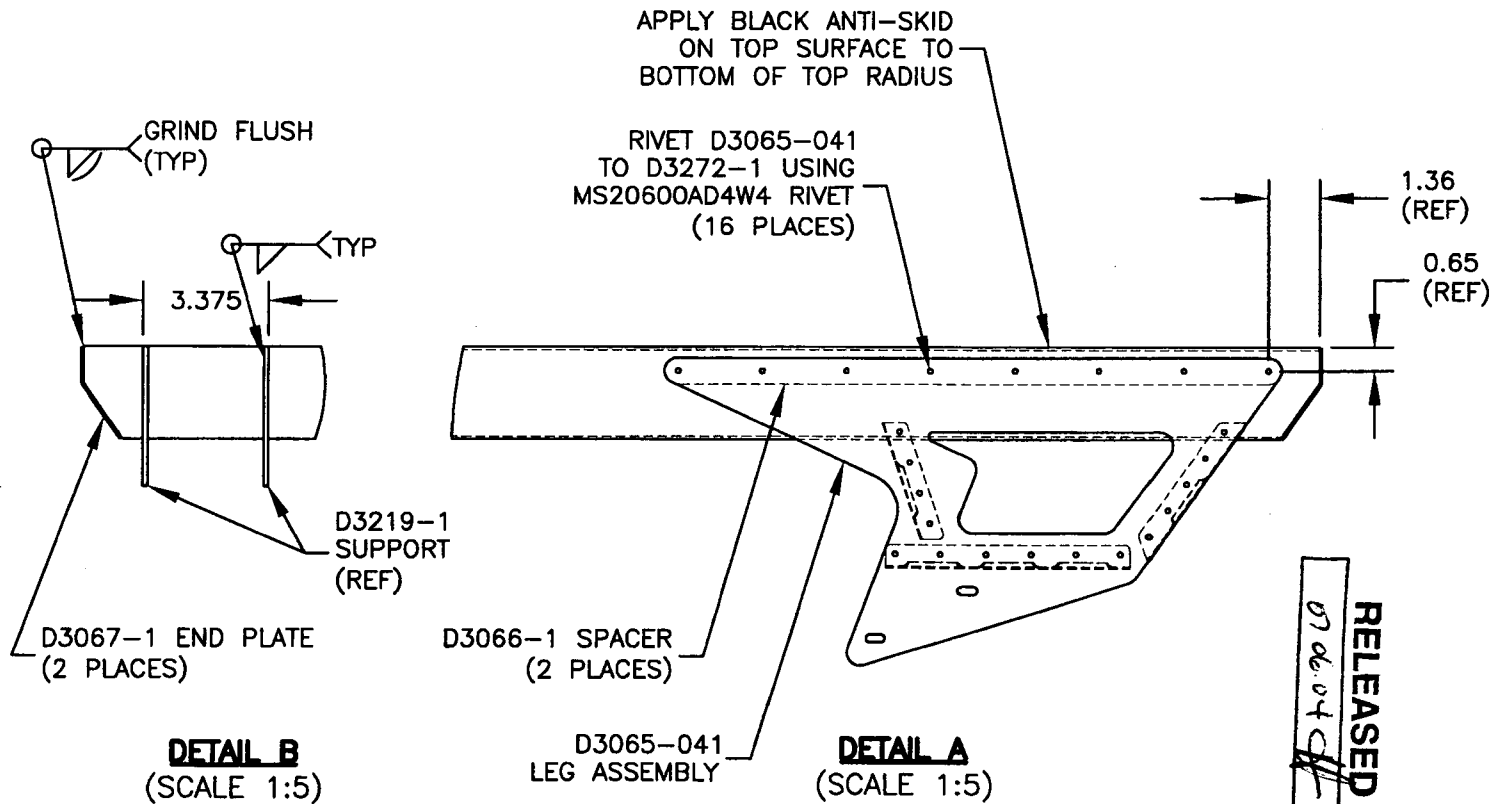
**DART**

DESIGN	99	DRAWN BY		<b>DART AEROSPACE LTD</b>
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	

77761



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

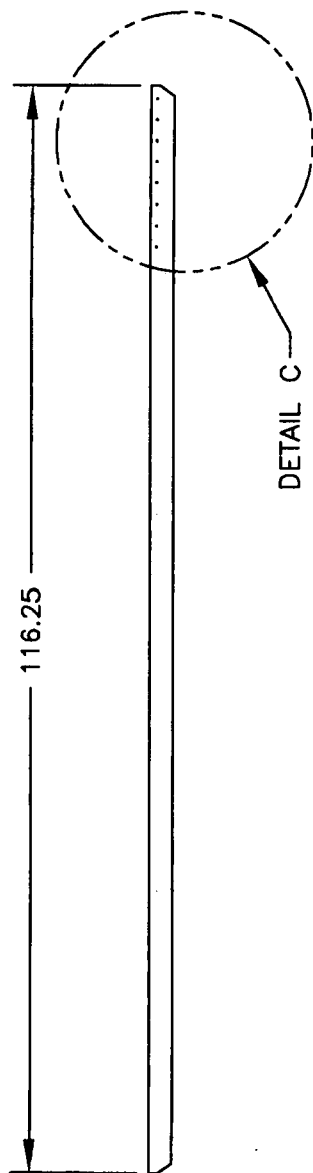
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

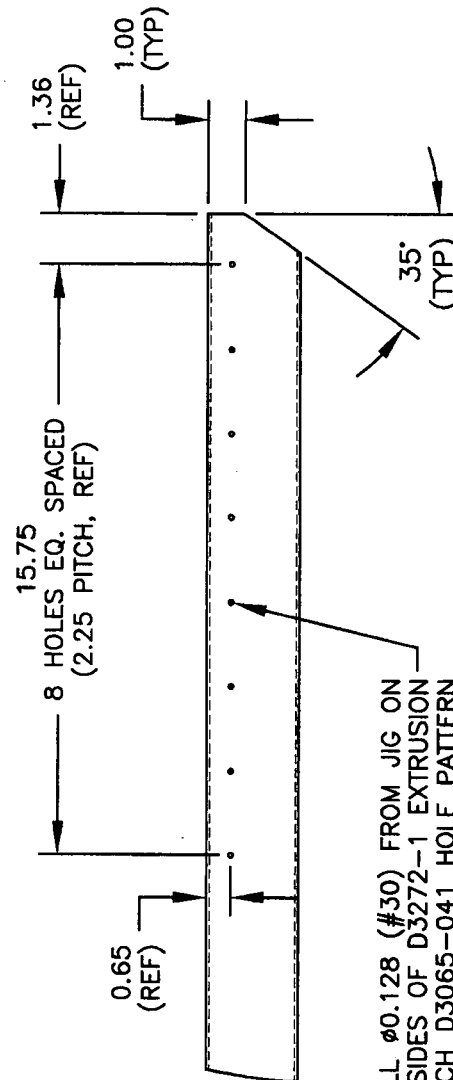
**DART**

DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



**RELEASED**

07.06.04 *[Signature]*

**DETAIL C**  
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.